

20

DART AEROSPACE LTD	Work Order:	20771
Description: Bearpaw Kit (13" x 24")	Part Number:	K10006
Dwg: D2672 Rev. B1	Qty:	4 Kits
Ref: K10006 Rev. C; DSK086-2 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10006 Kit consists of Qty (2) D2672F Dwg not required	HA	04.04.28	4																																																
2	DC	Photocopy bluefile: K10006 D206-559-023 D350-578-021 and create labels per PPP K10006 CHG004 (Bag Bluefiles separately)	HA	04.04.30	4																																																
3	GA	Cut 2 blanks per (1) K10006 Kit Cut blank: 13.25" x 24.25" x 1.00" thick (+0.030/-0.000) per DSK086-2 Material: Black UHMW 1" (MUHMWB10) Batch: 14564 14716	EP	04.05.03	4																																																
4	MV	Inspect material for defects or damage prior to machining	EP	04/05/29	4																																																
5	MV	Machine as per Folio and Dwg D2672 Identify as D2672F	EP	04/05/024																																																	
6	QC2	Inspect parts as they come off the CNC machine	EP	04/05/024																																																	
7	MV	Deburr	EP	04/05/024																																																	
8	QC8 & 5	Second inspection	EP	04-05-03	4																																																
9	KP	Pick: Packing Kit (Note: D2672F is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B20655</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B20387</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B20388</td></tr><tr><td>2</td><td>D2672F</td><td>Bearpaw</td><td>B20771</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B20433</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>m14544</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>m14311</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>m14312</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m14149</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B20434	12	D2274	Radius Block	B20655	6	D2438	Clamp	B20387	12	D2529	Washer	B20388	2	D2672F	Bearpaw	B20771	6	D2732-050	Rubber Cushion	B20433	12	AN4-15A	Bolt	m14544	12	AN4-17A	Bolt	m14311	24	AN960JD416	Washer	m14312	12	MS21042L4	Nut (or -4)	m14149	1	Paperwork package from Step 2			EP	04/05/03	4
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10	QC4	Inspect Kit for 100% Completeness on the W/O	EP	04/05/03	4																																																
11	PK	Identify and pack for shipping as per PPP K10006	EP	04/05/03	4																																																
12	AC	Cost / part 166.23	EP	04/05/04	4																																																
13	DC	Close W/O 62.71 Inspect Level 21	EP	04.05.04	4																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10006 created for Bearpaw Kit	EC	
B	00.06.30	Relaced D2639 by D2981-0200-1600 (MPP 2072)	EC	
C	01.03.19	CHG002 (MPP 2117)	EC	
D	03.05.30	Reformat; Incorporated D2672F	KJ/RF	
E	04.02.17	Tolerance added to Step 3	KJ/JLM	

BB 04-05-04 DB

RELEASED
04.02.2004

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	20771
Description: Bearpaw		Part Number:	D2672
Inspection Dwg: D2672 Rev: B1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	✓		Tape Measure	
B	12.750	+/-0.030	12.750	✓		Tape Measure	
C	4.250	+/-0.010	4.253	✓		vern	
D	2.000	+/-0.030	2.010	✓		vern	
E	9.000	+/-0.010	9.005	✓		12" vern	
F	0.375	+/-0.030	0.390	✓		vern	
G	9.000	+/-0.010	9.005	✓		10" vern	
H	Ø0.260	+0.005/-0.000	Ø0.260	✓		vern	
I	Ø0.93	+/-0.030	Ø0.926	✓		vern	
J	0.300	+0.030/-0.000	0.316	✓		vern	
K	0.625	+/-0.030	0.626	✓		vern	
L	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		vern	
M	0.250	+/-0.010	0.265	✓		mic	
N	5.500	+/-0.030	5.496	✓		vern	
O	R0.250	+/-0.030	R0.250	✓		Radius Gauge	
P	0.200	+/-0.030	0.206	✓		vern	
Q	0.25 x 45°	+/-0.030	0.249 x 45°	✓		vern	
R	0.950	+0.030/-0.010	0.956	✓		vern	
S	0.375	+/-0.010	0.383	✓		vern	

Measured by: <u>CD</u>	Audited by: <u>EE</u>	Prototype Approval:	N/A
Date: <u>04/04/30</u>	Date: <u>04.04.30</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10006	KJ/RF	<u>[Signature]</u>

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 27, 2004
03:08 pm

Work Order No : 0020771
Project Name : *K10006
Project For : WK420
Work Order Type : Main
Main WO Number :
House Part Number : *K10006
Description : Bearpaw Kit 13" x 24"
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 04-27-04
Est Finish Date : 05-11-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00